

Date: Monday, 27/04/2009 2:30:07 PM
User: Linda Lacelle

AOG

Process Sheet

Spit

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 47553		
Estimate Number	: 12172		
P.O. Number	:	Part Number	: D2066
This Issue	: 27/04/2009 S.O. No. :	Drawing Number	: D2066 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 34919	Material	:
Written By	: <u> </u>	Due Date	: 28/04/2009 Qty: <u>4</u> Um: Each
Checked & Approved By	: <u> </u>		
Comment	Est. D 02.03.18 Added pick list NG est E 07.10.03 removed p/c EC verified by: DD Est Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2052 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10~~ 8.0000 Each(s)
Bracket
batch: B39556

FF. 09-04-29

(4)

2.0 D2054 Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10~~ 8.0000 Each(s)
Bushing - Delrin
batch: B39433

FF. 09-04-29

(4)

3.0 D2055 Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~8~~ 4.0000 Each(s)
Clamp
batch: B34365

FF. 09-04-29

(4)

4.0 D2056 Bell Crank



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~5~~ 4.0000 Each(s)
Bell Crank Assembly
batch: B39434

FF. 09-04-29

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 2:30:07 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47553

Part Number: D2066

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~20.0000~~ 16 Each(s)
Washer

batch: M 110905

FF 09-04-29

(4)

6.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)
Nut

batch: M 110844

FF 09-04-29

(4)

7.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~10.0000~~ 8 Each(s)
Screw

batch: M 1108161

FF 09-04-29

(4)

8.0

M304TR0500W049

304 RD Tube .500 x .049W



Comment: Qty.: 2.5053 f(s)/Unit Total : ~~12.5265~~ 10,0212 f(s)
304 RD Tube .500 x .049W
304/316 SS Seamless Tube
batch: M 110968

FF 09-04-29

(4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1 OK u
1-Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube
(Ref QSI 017 4.1.1.2) as per Dwg D2066 (per D2727)
Use punch Jig DT8012

2-Slide on parts per Dwg and W/O for D2676-043

3-Punch other end to length (28.62") as per Dwg D2066

4-Bend per Dwg D2066

5-Drill 3/16" (0.188") Dia holes per Dwg D2066 using drill jig DT9034

FF 09-04-29

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 2:30:07 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 47553

Part Number: D2066

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Polish and Deburr

7- assemble parts as per dwg D2066

FF 09-04-29

(4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/28 (X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 220.

SS 09/04/30 (X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



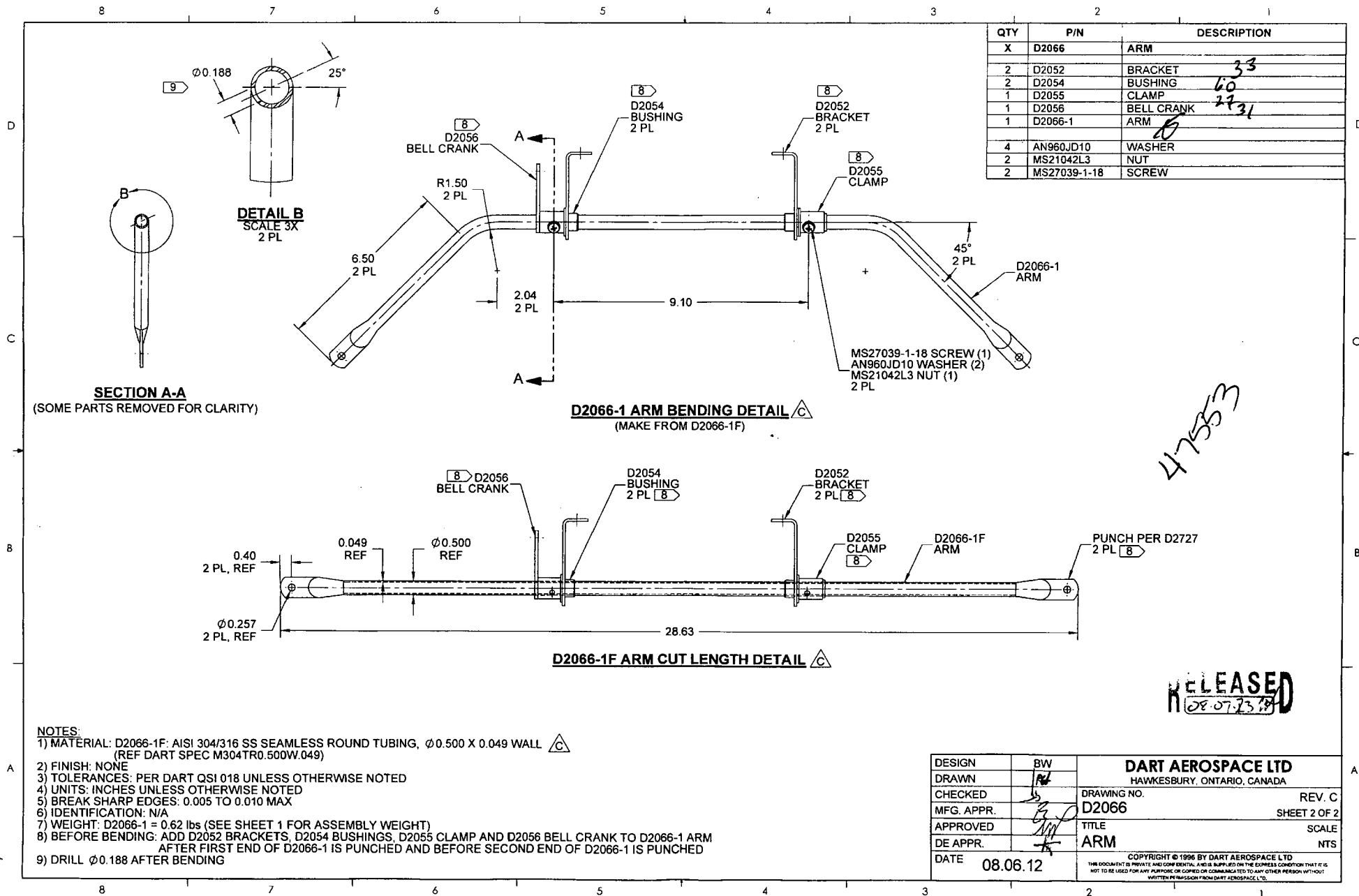
Comment: FINAL INSPECTION/W/O RELEASE

09/04/30 J2

Job Completion



MF 09-04-30



8 7 6 5 4 3 2 1

D

D

C

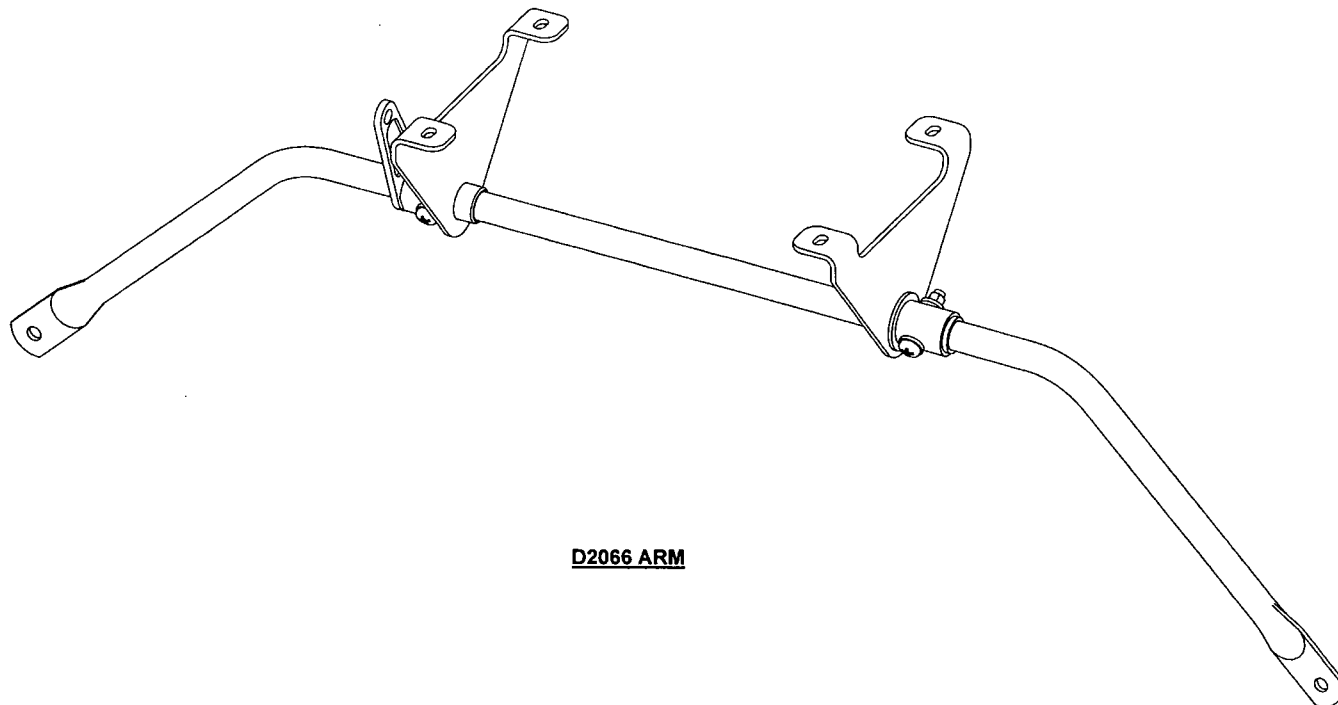
C

B

B

A

A



D2066 ARM

RELEASED
08.07.13/10

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2066" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.85 lbs

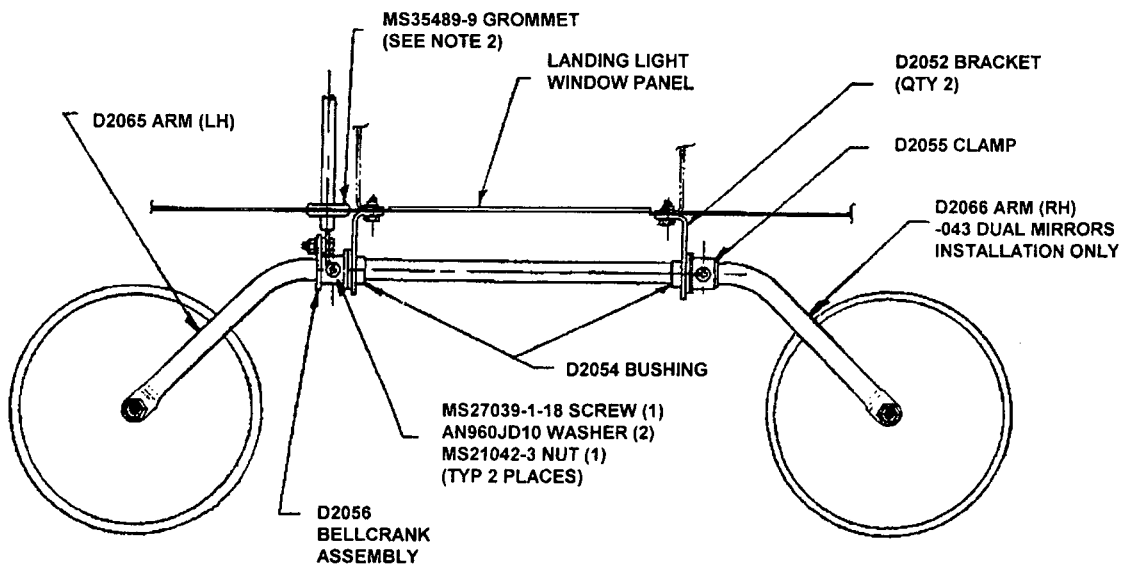
C	REDRAWN IN SOLIDWORKS; ADD D2066-1F CUT LENGTH DETAIL (ZN B4-2) AND D2066-1 BENDING DETAIL (ZN C4-2) FOR D2066: Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2). REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.12
B	RE-DESIGNED	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	32	D2066	SHEET 1 OF 2
APPROVED	14P	TITLE	SCALE
DE APPR.	14P	ARM	NTS
DATE	08.06.12	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

3.0 CARGO MIRROR INSTALLATION

Install the Cargo Mirror as follows:

1. Install D206-558-041/-043 cargo mirror assembly using AN3-4A bolts and AN960JD10L washers. Pickup existing anchor nuts in 4 places.
2. Install D2067 connector onto D2056 bellcrank assembly to locate hole for MS35489-9 grommet. With the mirror in the deployed position, mark and drill $\varnothing 0.125$ " (3.2mm) hole in landing light window panel where the grommet should be located. Open pilot hole to $\varnothing 0.563$ " (14.3mm). Install grommet.
3. Install D2053 bracket using AN526-1032R9 screws. Pickup on existing anchor nuts.
4. Position D2071 cable as shown. Install MS21919DG5 clamps using AN526-1032R9 screws where required. Pickup existing rivnuts or anchor nuts if available.
5. Install D2071 control cable using D2067 connector. Connector should rotate freely in bellcrank when MS21042-3 nut is torqued and cable clamped



**Figure 2: – View A: Looking Aft.
(D206-558-043 Mirror Shown)**